

Work Order ID 56353

February 19, 2010 8:36:39 AM



Page 1

Item ID: D3189-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Chafing Shield

Start Date: 2/19/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/25/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 10-2-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3189

Rev B

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut to size as per Dwg D3189

[Signature] 10/03/03 (20)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr & Grind Rads as per Dwg D3189
2-Roll as per Dwg D3189

[Signature] 10/03/03 (20)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Solo 10/04

count
(420)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56353

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: *X-tube*

0.00



Packaging

Memo

0.00

Packaging

<i>ml</i>	<i>10</i>	<i>03</i>	<i>08</i>	<i>20</i>
-----------	-----------	-----------	-----------	-----------

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11
mf
10-3-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 19, 2010 8:36:43 AM

Page 1

Work Order ID: 56353



Parent Item: D3189-1



Parent Item Name: Chafing Shield

Start Date: 2/19/10

Required Date: 2/25/10

Comments: IPP B 05.08.22 No longer made in-house KJ/JLM
 IPP Rev:C 06-03-24 Rolling Now made in House JLM
 IPP Rev:D 07-04-16 As per Rev B JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S25GA		Purchased	No			100	sf	40.0131	6.7368			



304/316 .020" Sheet



Handwritten: 2/10/23/03
 M106236 : 6.7368

Handwritten: M304S24GA

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

40.0131

107436

32.74

107513

7.2731

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED07.03.27 *[Signature]*

11.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *56353*

PM 10-2-19

4.13

D3189-1 FLAT PATTERNR0.063
(TYP) $\phi 3.3$ D3189-1 ROLLING DETAIL
NOT TO SCALED3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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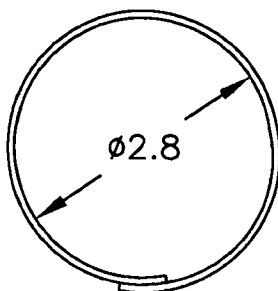
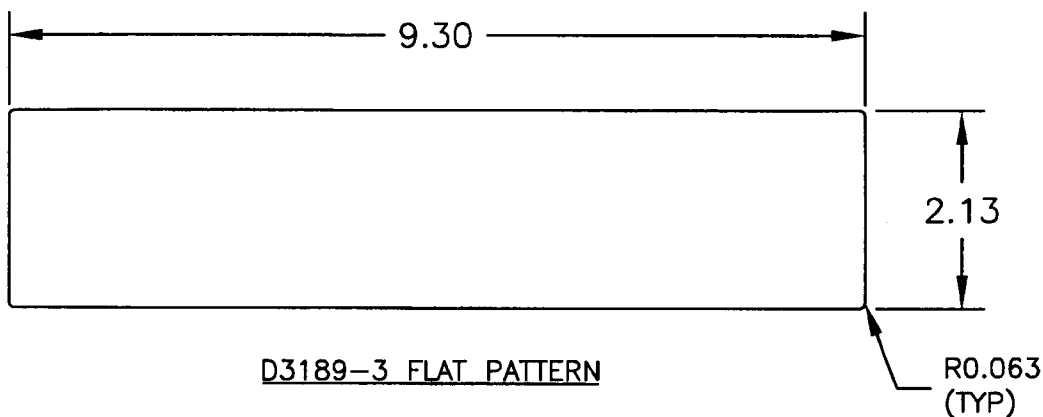


DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 *[Signature]*

w/o 54353



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
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